

Date: Friday, 28/03/2008 12:42:18 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING CAP
Job Number : 38233	
Estimate Number : 12412	
P.O. Number :	Part Number : D312125
This Issue : 28/03/2008 S.O. No. :	Drawing Number : D3121 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type MACHINED PARTS	Drawing Revision : E
Previous Run : 36151	Material :
Written By : <i>[Signature]</i> 08-03-28	Due Date : 04/04/2008 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est Rev/A New Issue 06-05-10 JLM	
Est Rev:B ECN 1060 07-11-12 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELIRINR12500	DELIRIN ROUND BAR 1.25"
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Comment: Qty.: 0.0546 f(s)/Unit Total: 1.6380 f(s)
Material: Ø1.25 Delrin Rod
(M-DELIRIN-R1.2500) Identify as D3121-25
Batch: *M104308*

08-03-29

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

08-03-29

30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08-03-29

30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/03/29

30

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *66*

08/3/31 (30)

08-03-28

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING CAP

Job Number: 38233

Part Number: D312125

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08 04.01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

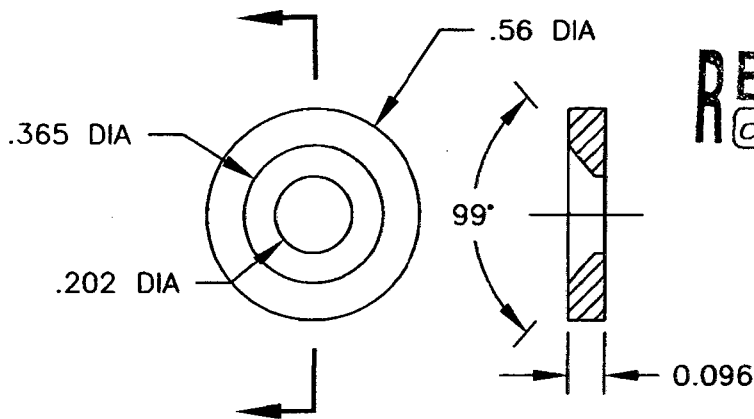


mf

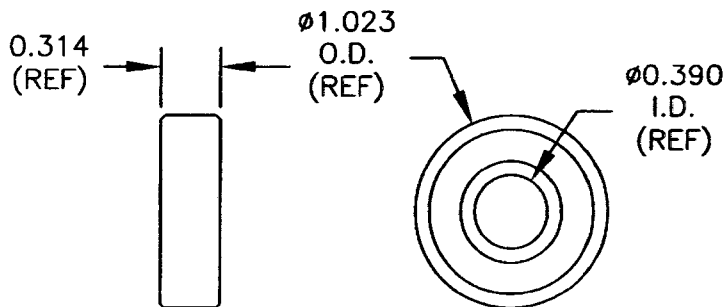
08-03-31

DART

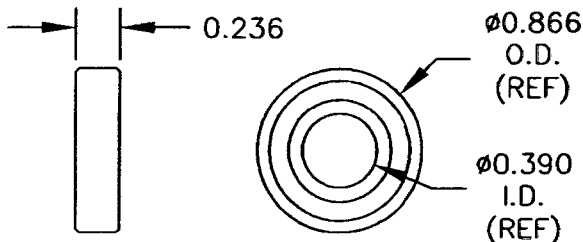
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

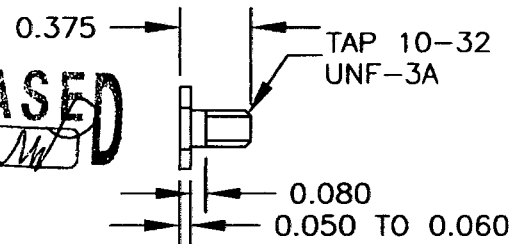
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

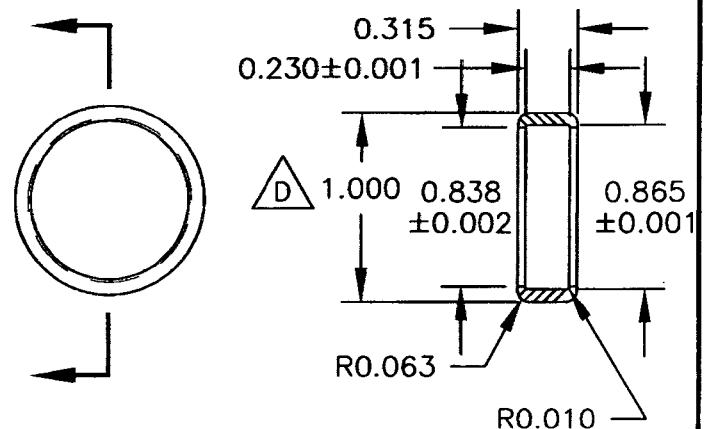
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

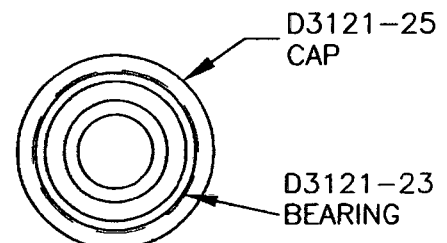
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

w/o 38233**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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DART AEROSPACE LTD		Work Order: 38233
Description: Cap		Part Number: D3121-25
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.315	+/-0.010	.315	✓			
Ø1.000	+/-0.010	1.000	✓			
Ø0.838	+/-0.002	.838	✓			
R0.063	+/-0.010	.063	✓			
R0.010	+/-0.010	.010	✓			
0.230	+/-0.001	.229	✓			
Ø0.865	+/-0.001	.865	✓			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 08.03.29	Date: 08/03/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD 